110

~ \*110\*

Quality Control

112

Quality Control

QC2- Inspect parts off machine FAI/FAIB

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

**POSITIVE RECALL** 

EFFECTIVE 14/4/24 AUTH

See ENG for orientation for CNC

D HORDS

DQA:	Just Of	•	14/1 14/		WORK ORDER NON	-cc	ONFO	RMANCE / UPDATE	Work Order u	update only	DART
Work Order:	114	453	33		DISPOSITION				DEPARTMEN		
	D3:		_		Rework Scrap Use-as <sub>Ţ</sub> is X Suspected Unapproved			Skid-tube Crosstube  Machining Small Fab  noforming Finishing  Large Fab Composite	Rec/St	Water Jet od. Eng. Coor. pre/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	Desci •	iption of work order update or non-conformance	1	nitial ief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	14/03/10	b 100	*1	by has betwee  RC. ** Corach No: Prove	steapy lest wasn't solur by. Locks were not set. n process check list h st no correct well 2 0.098	14	DAS 12 989	Cleate a un progres set up chek har? List to Prove [validad set up	ess 35 2:4.	14-11-2	14ko/23
Landing	Gear	<u> </u>			General	FAL	ULT CA	TEGORY			8.3
2 T	Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Turning So	nk/Ripple t n Strip in atter equence	/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspect Instruc Misalia Mislaba Misrea Off-set Out of	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled d	Outside Di Over/Unde Part Incorr Part Lost/N Part Move Positioned Power Los	er tolerance ect Aissing d Wrong s/Surge	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled  Other

MAIN T

### Work Order ID 114533

140

Quality Control

QC8- Inspect parts - second check

\*114533\*

March-10-14 8:25:20 AM \*N900040100\* D3391-025 Item ID: Accept Setup Start **Revision ID:** Aft Tube Assembly Item Name: 3/10/14 Start Qty: 1.00 **Start Date: Cust Item ID:** Required Date: 3/24/14 Req'd Qty: 1.00 **Customer:** Reference: Approvals: **Tooling:** SPC (Y/N): Date: Sequence ID/ Too! ID Too! # Plan Operation e Set Up/ . Accept Reject Reject Work Center ID Description Number **Run Hours** Code 'Qty **Qty** Stamp 120 0.00 DAS \*120\* EFFECTIVE 49/9/25 ALPT HAAS 1 "1-Machine as per Folio FA 599 Rev: \ & Dwg D3391 Rev: \ RELEASED HAAS CNC vertical machine #1 DAS QC2- Inspect parts off machine FAI/FAIB 20 0.00 Memo Quality Control

0.00

0.00

14-10-22

Pro

DQA:	Date: <u>/ //</u>	12/13.								DART
QA Closed:	Date: N	F/17/	WORK ORDER NON-	-CC	NFO	RMANCE / U		ork Order up	date only	AEROSPACE
Work Order:	4533		DISPOSITION			**	AGAINST DE	PARTMENT	/PROCESS	
	1391-02 4450		Rework Scrap Use-as-is X Suspected Unapproved		-	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root			cription of work order update		nitial		tion	Sign & Date	Verification	QC Inspector
Cause , Da  Design	e Step Ot	CHA	or non-conformance		ief Eng A.P		ription netween 033 <i>91-02</i> 5 And 03391-025	DAS <b>20</b>	A.R.	QC IIISPECTOI
Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		OF ASS VID	D3391-025 APT TUDE YEAS A RESULT OF THE TOP	<u> </u>		AFT TUSE ASS IS THE WEAR A SMESS DISTRICT THE D 3391-047 THEREFORE ACC BLEND CHATT SMOOTH TRANS SURFACE SHOUL OR BETTER TO MACHINED SU	SY BY COMPANSON  THE THE THOUGH  ASSEMBLY.  EPPANIE TO  ER. ENURE  THOON. FINISH  LYSE EQUAL TO  HAN GYRCLAST	A.Q. 14.10.20	14.10.20	id 1, d 23
i andian Canad		· · · · ·	A A	FAL	JLT CA	regory				* y ·
Crack Crimi Cuffs Crush Heat	ng e Not Concentric s /Kink/Ripple/Wa		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing		Grain Hardwa Inspect Instruct	ion Incomplete/Ui ions Incomplete/U gned/off center eled	Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ensions tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
Mark	s/Chatter		Drill Holes		Off-set					<u></u>
. <del>.</del>	ng Sequence /Twist in Tube		Finish Fit/Function	-	,	Calibration Sequence			<u></u>	

Required Date: 3/24/14

Item ID:

D3391-025

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

Item Name: Start Date:

Aft Tube Assembly

3/10/14

Start Qty: 1.00 Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals: **Process Plan:**  Date:

**Tooling:** 

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Run

Reject ... Insp Number

150

Skidtubes

\*150\* Skidtubes

Skidtubes

Memo

0.00

0.00

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

\*160\*

BENDING MACHINE - SKIDTUBES

QC5- inspect part completeness to step on W/O

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

0.00

Form as per Dwg D3391 Using Bend Prog 3391025

**POSITIVE RECALI** 

EFFECTIVE 14/9/25 AUTH 5

RELEASED DATE 14-11-12

to cleek ounter

1-70

Memo

0.00

0.00

Quality Control

14-11-12

H-4,150

		, might the second	. %.	, ,	*					<i>i</i> ,			: <b>!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!!</b>	
		*5** * 3	WAR FELL	g gents Garage	<b>(</b> *)	yer en la		•	<b>Y</b> .	See Mills				
	DQA:		Datë:	<u> </u>	), m				W.					NOVAVRIT
		2.3				WORK ORDER NON	-CC	NFOF	RMANCE / U	IPDATE				AEROS PACE
	QA Closed:	- A	Date:	- N							Wo	ork Order up	date only	
	Work Order:	hig.	. 144			DISPOSITION			No.	AGAINS	T DE	PARTMENT	/PROCESS	
	Work Order.		<del></del>			Rework	1 <b> </b>		Skid-tube	Crosstub	۔		Water Jet [-	Engineering
	Part No.					Scrap			Machining	Small Fa	<u> </u>	Pro	d. Eng. Coor.	Quality
						Use-as-is			noforming	Finishir	-		re/Packaging	Other
	NCR No	•	in the second	3.		Suspected Unapproved	]		Large Fab	Composit	ie 🔃	•* *	Supplier	
				4.55						*			·	¥*,
	Root			1	Desc	ription of work order update	1	nitial		tion		Sign &	., .,.	
	Cause	Date	Step	Qty		or non-conformance	Ch	ief Èng	Desc	ription		Date	Verification	CQC Inspector
	Design Doc/Data	-	]					•				:		
	Equip/Tooling	-								* - 4 * * *				
	Handling/Pre	1	}		1		Ì							1
	Material		1							<b>,</b>	-			,
•	Operator	]			:									
ŕ	Offset/Setup							•						
To Barrell	Process		4. 18 g . mg-											
	Supplier		* 554+	, V			ļ							13.5
÷	Training **		اً ـ ـ ـ ـ ـ ـ ـ ـ ـ ـ ـ ـ ـ ـ ـ				]		:					
	Transport Unapproved		1750			da	l.,	4				,		
	Oliapproved	4 Mar. 1	175	1	l	Mar. 1			EGORY				<u> </u>	
	Landing	Gear **\	<u> </u>			General -					-		<del></del>	
	•	Bending				Bend TAG	8	Folio/P	rogram			Outside Dim	ensions	Pressure/Forced
		Centre No	ot Conce	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
بر مسمور د ماهمان		Cracks				Broken/Damage/Defect	Ш	Hardwa			$\perp$	Part Incorre		Temperature/Cure
, 2°		Crimp/Kii	nk/Ripple	e/Wave	_	Burrs	-		on Incomplete/U		$\vdash$	Part Lost/M	issing	Weld Wrong Stock Pulled
1		Cuffs			-	Contamination	-		ions Incomplete/		-	Part Moved		Wrong Stock Pulled
	7	Crushing			-	Countersink Cut Too Short	_	Misalig  Mislabe	ned/off center			Positioned V Power Loss/		Other
	-	Heat Trea		i'Tube		Drawing	`—	Misread				I OMEL LOSS/	Juige _	Tourer
	-	Marks/Ch	-	ilube		Drill Holes	$\overline{}$	Off-set	•					
, 14		Turning S		<b>:</b>		Finish	$\vdash$		Calibration					
, i	<del> </del>	Wave/Tw				Fit/Function		Out of 9	Sequence					

# \*114533\*

Wests Ocaer ID 174533

Manch-10-14 8:25:20 AM

Item ID: D3391-025 Accept \*N9000401 Setup Start **Revision ID:** Stop Aft Tube Assembly Item Name: **Start Date:** 3/10/14 Start Qty: 1.00 Cust Item ID Required Date: 3/24/14 Req'd Qty: 1.00 Customer: Reference: Start Run **Process Plan:** Approvals: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Reject Tool ID Sequence ID/ Tool # Plan Operation Set Up/ Accept Qty Qty Work Center ID Description **Run Hours** Code 0.00 180 Skidtubes \*120\* Skidtubes 0.00 Memo 1-Open Aft cap pilot hole to .208" as per Dwg D3391 Skidtubes 2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only. 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig. \*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\* 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.

14-11-14

Reject

Number

Insp.

Stamp

8- Scribe batch # on fwd end

7-Deburr

DQA:	Date:											
					WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		Date:							W	ork Order up	date only	
Work Orde	er:				DISPOSITION			AGAINS'	T DE	PARTMENT	PROCESS	
			•	_	Rework	1		Skid-tube Crosstube	e	] '	Water Jet	Engineering
Part N	lo.				Scrap	1 1		Machining Small Fal	—	Pro	d. Eng. Coor.	Quality
	4				Use-as-is	1	Therr	noforming Finishin	g	Rec/Stor	e/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab Composite	e 🗌	]	Supplier	
	<del></del>	1	1	D		ᆜ		A -4:		Cian 0		
Root	D-4-		0.	Desci	ription of work order update	1	nitial	Action		Sign & Date	Verification	QC Inspector
Cause	Date	Step	Qty		or non-conformance	Cn	ief Eng	Description		Date	verification	QC Inspector
Design Doc/Data	<b>-</b> ∤.											
Equip/Tooling					•					**		,
Handling/Pre	$\dashv$											
Material	$\dashv$											
Operator		_			/							
Offset/Setup		-										
Process												·
Supplier												
Training												
Transport								·				
Unapproved		ļ			·	<u>L</u>						
	·.				- <u>-</u>	FA	ULT CA	TEGORY				
Landir	ng Gear			,	General				_	7		<u>,</u>
	Bending				Bend	_	• •	Program	<u> </u>	Outside Dim	·	Pressure/Forced
,	Centre No	ot Conce	ntric	ļ	BOM/Route		Grain			Over/Under	<b>⊢</b>	Set-up
	Cracks				Broken/Damage/Defect		Hardwa		_	Part Incorred	<u> </u>	Temperature/Cure
	Crimp/Kink/Ripple/Wave				Burrs		4 '	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
,	Cuffs			<u> </u>	Contamination	$\vdash$	4	tions Incomplete/Unclear	<u> </u>	Part Moved		Wrong Stock Pulled
ļ	Crushing				Countersink		4	gned/off center	_	Positioned V		<b>7</b>
	Heat Trea				Cut Too Short		Mislab	i i		Power Loss/	Surge	Other
	Inspectio	•	Tube	<u> </u>	Drawing	_	Misrea					
	Marks/Ch				Drill Holes		Off-set					· · · · · · · · · · · · · · · · · · ·
	Turning S	-			Finish		Out of	Calibration				
	Wave/Tw	ist in Tul	be	l l	Fit/Function	1	Out of	Sequence				

Quality Control

D3391-025 Accept Item ID: Setup Start \*N900040100\* **Revision ID:** Item Name: Aft Tube Assembly Start Date: 3/10/14 Start Oty: 1.00 Cust Item ID: **Req'd Qty:** 1.00 Required Date: 3/24/14 **Customer:** Reference: Run Process Plan: Date: Tooling: Approvals: Date: QC: Date: SPC (Y/N): Date: Operation Set Up/ Tool ID Tool # Plan Reject Reject Insp. Sequence ID/ Accept Number Stamps Qty Work Center ID **Description Run Hours** Code Qty 190 QC5- Inspect part completeness to step on W/O 0.00 \*100\* OC 0.00 Memo Quality Control 200 Chemical Conversion Coat per QS1005 4.1 0.00 \*200\* HandFinish 0.00 Memo Hand Finishing 14-11-18 QC7-Inspect Chemical Conversion Coat 210 0.00 0.00 Memo

DQA:			Date:						_					TRAGG
OA Classid			Data			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	\A/.	ork Order up	data only		AEROSPACE
QA Closed:			Date:					1		VV	ork Order up	date only		
Work Orde	er:					DISPOSITION			AGAIN	IST DE	PARTMENT	PROCESS		·
	-			· **		Rework	1		Skid-tube Crosstu	be	]	Water Jet		Engineering
Part N	No.					Scrap	1.	1	Machining Small F		Pro	d. Eng. Coor.	П	Quality
*	-	-				Use-as-is			noforming Finish	ing	Rec/Stor	e/Packaging	П	Other
NCR N	No.					Suspected Unapproved			Large Fab Compos	ite		Supplier		
Root	ł		İ		Desc	ription of work order update	ŀ	nitial	Action		Sign &	_		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verificatio	n	QC Inspector
Design														
Doc/Data	_		'											
Equip/Tooling	Щ	-												
Handling/Pre	Щ													
Material	Щ	_												
Operator	Н													
Offset/Setup	Щ						ļ				ļ			
Process			-											
Supplier	Щ			<u>.</u>										
Training	-													
Transport	$\dashv$		1				1							
Unapproved		<del></del>	<u> </u>	<u> </u>	<u></u>			UTCAT	I CORV		<u> </u>			
Landii						General	FA	OLI CA	regory	·				
Lanuii		Bending			Г	Bend		leolio/e	Program		Outside Dim	ansions	$\overline{}$	Pressure/Forced
	$\vdash$	Centre No	ot Concer	ntric	$\vdash$	BOM/Route		Grain	TOGIATTI	<u> </u>	Over/Under		$\vdash$	Set-up
	$\vdash$	Cracks	ot concer	ILLIC	-	Broken/Damage/Defect		Hardwa	ırα		Part Incorred		-	Temperature/Cure
	-		nk/Rinnle	/Mayo	-	Burrs	$\vdash$	4	ion Incomplete/Unqualified	-	Part Lost/Mi		<u> </u>	Weld
	Crimp/Kink/Ripple/Wave					Contamination	-	4 '	ions Incomplete/Unclear	<u> </u>	Part Moved	331116		Wrong Stock Pulled
	Crushing					Countersink	-	4	ned/off center	$\vdash$	Positioned V	Vrong		]
		Heat Trea				Cut Too Short	$\vdash$	Mislabe			Power Loss/	_	Г	Other
	—	Inspectio		Tube	<u> </u>	Drawing	<b> </b>	Misrea		<u> </u>	J. 5.1.5. 2533/	- · · · · · · · · · · · · · · · · · · ·		<u> </u>
	-	Marks/Ch	-		-	Drill Holes		Off-set						
	ш	Turning S				Finish		4	Calibration			•		<u> </u>
•	-	Wave/Tw				Fit/Function		4	Sequence			······································		

Quality Control

March-10-14 8:25:20 AM Item ID: D3391-025 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Aft Tube Assembly Start Oty: 1.00 **Start Date:** 3/10/14 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 3/24/14 **Customer:** Reference: Run **Process Plan: Approvals:** Date: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Reject Operation Tool ID Tool # Plan Reject Set Up/ Accept Insp. Number Stamp **Work Center ID** Qty **Description** Code Qty **Run Hours** 0.00 220 Skidtubes \*220\* Skidtubes Memo 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: 12917 exp. date: 14-12-30 cure time 12hrs as per QSI0015 Skidtubes 2- Grind crossbolts flush 14-11-19 3- Back drill using #9 drill 4- Touchup Magnabond 5- Deburr DAS 230 QC5- Inspect part completeness to step on W/O 0.00 0.00 Memo

DQA:		WORK ORDER NON-CONFORMANCE / UPDATE												
						WORK ORDER NON	-CC	ONFO	RMANCE / UF					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	PROCESS		
				<u> </u>		Rework			Skid-tube	Crosstube	7	Water Jet	$\Box$	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	П	Quality
						Use-as-is			noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR N	٧o.					Suspected Unapproved			Large Fab	Composite		Supplier		
													·	
Root					Desc	ription of work order update	ı	nitial	Act		Sign &		- [	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verificatio	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling											r e			
Handling/Pre														
Material													ĺ	
Operator														
Offset/Setup														
Process Supplier														
Training														
Transport							}							
Unapproved							1							
				<u> </u>	L		FA	ULT CA	TEGORY	-	<u>. L</u>			
Landi	ng (	Gear				General								
		Bending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
*		Cracks				Broken/Damage/Defect		Hardwa	are	L	Part Incorre	ાં		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	_	Burrs	L	Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	$\vdash$	Weld
		Cuffs				Contamination		4	tions Incomplete/L	Inclear	Part Moved			Wrong Stock Pulled
	<u> </u>	Crushing				Countersink		•	gned/off center	<u> </u>	Positioned V			l
	<u> </u>	Heat Trea				Cut Too Short	<u></u>	Mislabe		Ļ	Power Loss/	Surge		Other
	<u> </u>	Inspection	•	Tube	<u> </u>	Drawing		Misrea						
	ldash	Marks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set						
	<u> </u>	Turning S	*		$\vdash$	Finish	_	ł	Calibration					
		Wave/Tw	rist in Tub	e		Fit/Function		Out of	Sequence					

Required Date: 3/24/14

Item ID: **Revision ID:**  D3391-025

Accept

\*N900040100\*

Setup Start

Item Name: **Start Date:** 

3/10/14

QC:

Aft Tube Assembly

Start Qty: 1.00 Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Tooling:

Date:

Run

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID

235

Description Pressure Wash per QSI005 4.3

Operation

Set Up/ **Run Hours** 0.00

Tool ID

Tool # Plan Qty Code

Reject Accept Qty

Reject Number Stamp

Insp.

\*225\*

HandFinish

Memo

0.00

0.00

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

240

\*240\*

! Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

250

**Quality Control** 

FINISH TIME: 0

QC3- Inspect Part Finish

Memo

0.00

0.00

1 \$ 14-12-1

tr 4 11 14/12/0 300

DQA:			Date:										
						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / U	PDATE		_	AEROSPACE
QA Closed:			Date:							V	ork Order up	odate only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
	-					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	۱o.			_		Scrap	]	ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	۱o. <mark>.</mark>					Suspected Unapproved	}		Large Fab	Composite	_]	Supplier	
Root					Desc	ription of work order update		nitial	Act	tion	Sign &		
Cause	i	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator							Ì						
Offset/Setup							ŀ						
Process													
Supplier												1	
Training													
Transport										•			
Unapproved										·		ļ	
							FA	ULT CAT	TEGORY	:			
Landi	ng G	Gear			<u> </u>	General						-	
		Bending				Bend		Folio/F	Program	L	Outside Dim	-	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		_	Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire	<u> </u>	Part Incorre	ci [	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/M	issing	Weld
ļ		Cuffs			L	Contamination		Instruct	tions Incomplete/	Unclear	Part Moved	Ĺ	Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center	Ĺ	Positioned \	Vrong	_
		Heat Trea	nt			Cut Too Short		Mislabe	eled	L	Power Loss/	'Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	d			<u></u>	
		Marks/Ch	natter			Drill Holes		Off-set					·
		Turning S	equence			Finish		Out of 0	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of s	Sequence				

Item ID: **Revision ID:**  D3391-025

Accept

\*N900040100\*

Setup Start

Item Name: **Start Date:** 

3/10/14

Start Qty: 1.00

**Cust Item ID:** 

Required Date: 3/24/14

**Req'd Qty:** 1.00

**Customer:** 

Reference:

Approvals:

**Process Plan:** 

Aft Tube Assembly

Date:

**Tooling:** 

0.00

0.00

Date:

Run

HandFinishing

SPC (Y/N): Date:

Date:

Sequence ID/ **Work Center ID**  Operation Description Set Up/ **Run Hours**  Tool ID

Tool # Plan Accept Code Oty

Reject Oty

Reject Insp. Number Stamp

260

\*260\*

Hand Finishing

HandFinish Memo

> 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291 M \3027 I Sikaflex expiry date:

3- INSTALL WEARPLATES AS PER DWG

270

QC5- Inspect part completeness to step on W/O

38

OC

Memo

0.00

Quality Control

280

Identify as per dwg & Stock Location: W/O

D412-742-043/B126411 14 de Ill 14/168

\*280\*

Packaging Packaging

Memo

0.00

DQA:		Date:												
						WORK ORDER NON	-CC	ONFO	RMANCE / L					AEROSPACE
QA Closed:			Date:							V	Vork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	PROCESS		
Part N	lo.				<del>-</del>	Rework Scrap Use-as-is			Skid-tube Machining	Crosstube Small Fab Finishing	<b>—</b>	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR N	۱o.					Suspected Unapproved	]		Large Fab	Composite		Supplier		
Root					Desc	ription of work order update		nitial	Ad	ction	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng		cription	Date	Verification	<u>1</u>	QC Inspector
Design Doc/Data Equip/Tooling		,				F			i i					
Handling/Pre														
Material											,			
Operator													1	
Offset/Setup	, 🗏 📗													
Process														
Supplier											ĺ			
Training				:										
Transport							1					i -		
Unapproved														
,	<u>.</u>						FA	ULT CA	TEGORY					
Landi	ng (	Gear				General		•		_		,		1
		Bending				Bend	<u> </u>	Folio/F	Program	_	Outside Dim		$\bigsqcup^{!}$	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain		-	Over/Under		<u> </u>	Set-up
		Cracks				Broken/Damage/Defect	<u>_</u>	Hardwa		L	Part Incorred		<u> </u>	Temperature/Cure
	Crimp/Kink/Ripple/Wave					Burrs		Inspect	ion Incomplete/l	Jnqualified	Part Lost/Mi	ssing	igsqcup	Weld
,	Cuffs					Contamination		4	tions Incomplete	<b>⊢</b>	Part Moved			Wrong Stock Puiled
	Crushing					Countersink	_	1	gned/off center	·	Positioned V	- 1		1
	L	Heat Trea				Cut Too Short		Mislabe		L	Power Loss/	Surge		Other
	_	Inspection	•	Tube	<u> </u>	Drawing		Misrea						
		Marks/Ch	atter		L	Drill Holes		Off-set			<del></del>			
		Turning S			L	Finish		-{	Calibration					
		Wave/Tw	ist in Tub	e .		Fit/Function		Out of	Sequence					<u> </u>

\*114533\*

Page 9

March-10-14 8:25:20 AM

Item ID:

D3391-025

3/10/14

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

Item Name: **Start Date:** 

Aft Tube Assembly

Cust Item ID:

**Customer:** 

Reference:

Approvals:

Required Date: 3/24/14

Process Plan:

Date:

Tooling: SPC (Y/N): Date:

Date:

Run

Stop

Sequence ID/ Work Center ID Operation **Description** 

Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

290

QC21- Final Inspection - Work Order Release

0.00

Memo

QC: Date:

Start Qty: 1.00

Req'd Qty: 1.00

0.00

Quality Control

DQA:	Date: WORK ORDER NON-CONFORMANCE / UPDATE												D	TRAC
						WORK ORDER NON	-CC	ONFO	RMANCE / UI				_	AEROSPACE
QA Closed:			Date:							V	Vork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	PROCESS		
	•					Rework	]		Skid-tube	Crosstube	] _	Water Jet	☐ E	Ingineering
Part N	Ю.		· · · · · · · · · · · · · · · · · · ·			Scrap	1 1	ľ	Machining	Small Fab	_	d. Eng. Coor.	$\dashv$	Quality
NCR N	٠٥٠.	· <u>-</u>			 :	Use-as-is Suspected Unapproved	}		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	<u></u>	Other
Root					Desci	ription of work order update		nitial	Act	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	<u>.                                    </u>	QC Inspector
Design	$\Box$										į			
Doc/Data				<b>!</b>										
Equip/Tooling														
Handling/Pre	<del></del>													
Material									1					
Operator	H													
Offset/Setup											Í		Ì	
Process				•					İ					
Supplier														
Training -	-						1				Ì			
Transport														
Unapproved				l			FAI	III T CAT	TEGORY		<u> </u>			
l a mali			•			Company	FA	ULI CA	IEGORT			<del></del>		
Landi	ng C	Bending				<b>General</b> Bend			rogram	Г	Outside Dim	ensions [	$\neg$	essure/Forced
:		Centre No	nt Concer	ntric	$\vdash$	BOM/Route	-	Grain	Togram	<u> </u>	Over/Under		<b>─</b> ─ſ	t-up
			or concer	IIIIC	-	Broken/Damage/Defect	-	Hardwa	aro	F	Part Incorred	F		mperature/Cure
	Cracks Crimp/Kink/Ripple/Wave					Burrs	-	4	ion Incomplete/Ui	ngualified  -	Part Lost/Mi	F	We	•
	Crimp/Kink/Ripple/Wave					Contamination	$\vdash$	1 .	tions Incomplete/U		Part Moved	1		rong Stock Pulled
	Crushing					Countersink		4	gned/off center	-	Positioned V	د Vrong		
	-	Heat Trea	ıt		-	Cut Too Short	-	Mislabe			Power Loss/		Ot	her
	_	Inspection		Tube		Drawing	$\vdash$	Misread		L		J .		
	_	Marks/Ch				Drill Holes		Off-set						<del> </del>
	<del>                                     </del>	Turning S				Finish		4	Calibration					<del></del>
		Wave/Tw	-			Fit/Function		4	Sequence					

#### **Picklist Print**

March-10-14 8:25:25 AM

Work Order ID: 114533

Parent Item:

D3391-025

Parent Item Name: Aft Tube Assembly

\*114533\* \*D3391-025\*

**Start Date: 3/10/14** 

Required Date: 3/24/14 Start Qty: 1.00

Required Qty: 1.00

Page 1

**Comments:** 

IPP Rev B 06-02-07

IPP Rev:C 06-03-28 Update Manuf. Instructions JLM

ECN773 dwg rev. D EC

IPP rev D 07.03.20 IPP rev E

revF dwg 07.11.07

rev G dwg ecn 1053p EC verified by: DD

ECN 1056 IPP Rev:F 07-11-13

DD verified by: EC

EC

IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H

11.11.14 AS PER REV.I DD verified by:JLM

	11.11.14 AS FER B	CEV.I DD Verme	u by.si.	111									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date St Issued	tatus
D4095-047		Manufactured	No			260	Each	18.0000	1	1			
*D4095-04 Wearpad Assembly	47*								**	13.120	5.23()	(x) Ill	whizloz
				Location	<u>1</u>	Loc	Oty	Loc Code					
				FP001		•	18		_		_		
					102241		2		_		-		
					108289		16		_		_		
D4095-049		Manufactured	No		•	260	Each	13.0000	1	1			
*D4095-04 Wearpad Assembly	49*								**	3 1264	195 (1	x) Ill	ululo z
				Location	<u>1</u>	Loc	Oty	Loc Code					
				FP001			12		_		-		
					109670		12		_		_		- \
		•		FP002			1		_		_		
					102216		1		_		•		
D6014-090		Manufactured	No			100	Each	69.0000	1	1			
*D6014-09									**				

Location Loc Qty Loc Code LG003 69 17 52

\_\_\_\_ mm/ 14/08/2(



DQA:		Date:	·									TRAC
QA Closed:		Date:			WORK ORDER NON-	-CC	NFOI	RMANCE / UI		Vork Order up	ndate only	AEROSPACE
an closed.		Date.				_				·	· !	1
Work Order	·••				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
					Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part No	o.	•			Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No	o				Suspected Unapproved			Large Fab	Composite		Supplier	]
Doot	<u> </u>		1	Doses	intion of work and an undata	لِــ	nitial	Act	ion	Sign 9.		T
Root Cause	Date	Ston	O+1/	Desci	ription of work order update or non-conformance		nitial ief Eng		iption	Sign & Date	Verification	QC Inspector
Design	Date	Step	Qty		or non-comormance		iei ciig	Desci	iption	Date	verification	QC IIISPECTOI
Doc/Data	_											
Equip/Tooling											:	
Handling/Pre	-					ŀ						
Material	-		i									
Operator	]											
Offset/Setup												
Process	-										•	
Supplier											i	
Training												
Transport	7											
Jnapproved												
						FAI	JLT CA	regory		-		
Landing	g Gear				General		•					-
	Bending				Bend		Folio/F	Program	L	Outside Dim	<del>-</del>	Pressure/Forced
	Centre No	ot Conce	ntric		BOM/Route		Grain		L	Over/Under	<del></del>	Set-up
L	Cracks				Broken/Damage/Defect		Hardwa		Ļ	Part Incorre		Temperature/Cure
_	Crimp/Kink/Ripple/Wave				Burrs	-		ion Incomplete/Ur	· -	Part Lost/Mi	ssing	Weld
L	Cuffs				Contamination	-	1	tions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled
	Crushing			$\vdash$	Countersink		•	gned/off center	<u> </u>	Positioned V		ا .
_	Heat Trea			<u> </u>	Cut Too Short		Mislabe		L	Power Loss/	Surge	Other
_	Inspection	•	Tube	<u> </u>	Drawing	<u> </u>	Misrea					
 	Marks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set					
_	Turning S			_	Finish	<u></u>	{	Calibration				
	Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence				

Work Order ID: 114533

Parent Item:

Parent Item Name: Aft Tube Assembly

D3391-025

\*114533\*

\*D3391-025\*

**Start Date: 3/10/14** 

Required Date: 3/24/14

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured

Manufactured

No

No

230

337.0000

Each

\*\*

\*D3670-4-200\*

Bushing

Location Loc Qty FG 10 87709 10 LG001 327 103880 60 109108 242 96240 25 270 Each

107857

110816

Loc Code

B119656 (14) Il 14/12/07

D2646

\*D2646\*

Aft Cap

\*\*

61.0000

Location Loc Oty Loc Code FG 85848 2 90495 2 FP001 57 103306 18

1

38

DQA:		Date: Date: WORK ORDER NON-CONFORMANCE / UPDATE												
						WORK ORDER NON	-CC	ONFO	RMANCE / L					AEROSPACE
QA Closed:			Date:								Nork Order u	odate only		
Work Orde	r:					DISPOSITION				AGAINST [	DEPARTMENT	/PROCESS		
	•					Rework	1		Skid-tube	Crosstube		Water Jet		Engineering
Part N	o.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	$\sqcap$	Quality
	•					Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR N	ο.	_				Suspected Unapproved			Large Fab	Composite		Supplier		
								Ĺ.,,						
Root					Desc	ription of work order update		nitial		ction	Sign &		-	
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	1	QC Inspector
Design	Ц										ļ			
Doc/Data	_						1				ļ			
Equip/Tooling														
Handling/Pre	re													
Material	Fre													
Operator											ļ		ĺ	
Offset/Setup														
Process														
Supplier	_		1											
Training	_												I	
Transport	_	,							 				1	
Unapproved			<b> </b>									<u>L</u>		
				·····			FA	ULT CAT	regory					
Landin						General	_	1 /_		г		. г		D /F
	$\dashv$	Bending			_	Bend	_	1	rogram	-	Outside Dim	ŀ	$\dashv$	Pressure/Forced
	_	Centre No	ot Concer	ntric	.	BOM/Route	$\vdash$	Grain		ļ	Over/Under	t t		Set-up
	-	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorre	+		Temperature/Cure
	-	Crimp/Kin	nk/Ripple	/Wave	-	Burrs	<u> </u>	4 '	ion Incomplete/	· · · · · · · · · · · · · · · · · · ·	Part Lost/M	•	-	Weld
}		Cuffs			_	Contamination		-1	tions Incomplete		Part Moved			Wrong Stock Pulled
	$\overline{}$	Crushing			_	Countersink	$\vdash$	-	ned/off center	r Į	Positioned \	· ·	$\neg$	O.I.
}	-	Heat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislabe		Ĺ	Power Loss,	'Surge {		Other
	-	Inspection	-	Tube	<u> </u>	Drawing	<u></u>	Misread				<del></del>		<u></u>
	Marks/Chatter Drill Holes							Off-set						
	$\neg$	Turning S			<u> </u>	Finish	<u> </u>	4	Calibration					
1 1		Wave/Tw	ist in Tub	e	- }	Fit/Function		Out of S	Sequence					

Work Order ID: 114533

Parent Item:

D3391-025

\*114533\*

Parent Item Name: Aft Tube Assembly

\*D3391-025\*

Start Date: 3/10/14

Required Date: 3/24/14

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured

No

270

Each

1,676.000

Il ululoz

\*D3672-1\*

<b>Location</b>	<u>I</u>	oc Oty	Loc Code	•	1
FG		10			
85222		10			
ST060		1666			
10384	5	4			
11221	3	500			
11358	<u>l</u>	500			X
93886		450			
99099		212			
	260	Each	1,136.000	14	14

ALS4-1032-130

AELS4-1032-130 Purchased

No

\*ALS4-1032-130\*

Rivnut

Location	<u>1</u>	<u>Lo</u>	e Qty	Loc Code		
ST279			1079			
	M128179		122			
	M128211		957	K1112861	19	
st510			57	1 446 0 00	1 (	<u> </u>
	M126109		57			
		270	Each	992.0000	8	8

ALS4-1032-225

AELS8-1032-225 Purchased

No

\*\*

\*ALS4-1032-225\*

Rivnut

Location	Loc Oty	Loc Code	11130579 (28) Il ululoz
FG	30		
M127028	30		
ST280	928		
M127028	10		
M128179	918		
st555	34		
M127092	34		

DQA:		Date:												TRAC
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Wa	ork Order up	ndate only	$\neg$	AEROSPACE
art closed.		Dutc.									PARTMENT			
Work Orde	r:				DISPOSITION									
					Rework			Skid-tube	Crosstube		Water Jet Engi			Engineering
Part N	0.				Scrap		Machining Small Fab				Prod. Eng. Coor.			Quality
					Use-as-is	Use-as-is Thermoforming			Finishing		Rec/Stor	re/Packaging	╗	Other
NCR N	o				Suspected Unapproved			Large Fab	Composite			Supplier		
		1	i					T			C: 0	<u> </u>	$\overline{}$	
Root		<b>.</b> .		Desci	ription of work order update	ŀ	nitial	Act			Sign &			001
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	+	QC Inspector
Design	_													
Doc/Data	_												Ì	
Equip/Tooling														
Handling/Pre	_	1												
Material	_	1		l										
Operator	_													
Offset/Setup			j		•								- 1	
Process		}												
Supplier														
Training														
Transport														
Unapproved												<u> </u>	丄	
						FAI	ULT CA	TEGORY						
Landin	g Gear			_	General		-				•	_		
_	Bending				Bend		Folio/F	Program		<u> </u>	Outside Dim	ensions	_	Pressure/Forced
L	Centre N	ot Conce	ntric		BOM/Route		Grain				Over/Under	tolerance	_	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	cí _	╝.	Temperature/Cure
	Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	匚	Part Lost/Mi	issing	'لـــ	Weld
	Cuffs				Contamination		instruct	tions Incomplete/l	Jnclear		Part Moved	L	'	Wrong Stock Pulled
	Crushing		•		Countersink		Misalig	ned/off center			Positioned V	Vrong _		
	Heat Treat Cut Too Short			Cut Too Short		Mislabe	eled			Power Loss/	'Surge	_]'	Other	
	Inspectio	n Strip in	Tube		Drawing		Misrea	d			_			
	Marks/Cl	natter			Drill Holes		Off-set							
	Turning S	Sequence			Finish		Out of	Calibration						
	Wave/Twist in Tube				Fit/Function		Out of Sequence							

#### **Picklist Print**

March-10-14 8:25:26 AM

Work Order ID: 114533

Parent Item:

D3391-025

Parent Item Name: Aft Tube Assembly

\*114533\* \*D3391-025\*

Start Date: 3/10/14

Required Date: 3/24/14

Start Qty: 1.00

\*\*

Required Qty: 1.00

\*AN3C4A\*

AN3C4A

Location Loc Oty

270

Each

Loc Code

2,081.000

M136716 (x6) Il wholoz

FG 20 20 122814 ST512 3 124221 ST513 2058 125388 1835 M127410 M127832 222 270 1,089.000 Each

AN3C5A \*AN3C5A\*

\*\*

EN130851(x4) Il (dulo3

Location Loc Qty Loc Code FG 5 5 122800 ST350 1084 M128057 1084 270 7,672.000 Each

NAS1149C0332R

Purchased

Purchased

Purchased

No

No

No

\*\*

10 M 130325 Cx10/ Il whiles

\*NAS1149C0332R\*

WASHER

Location	Loc Qty	Loc Code	
GA	1101		
125654	1101		
st510	6571		
m126319	. 61		
m127306	2500		
m127410	3000		
m127831 ·	1010		

DQA:			Date:													
						WORK ORDER NON	I-CC	ONFO	RMANCE	/ UPDATE					AEROSPACE	
QA Closed:			Date:					•	****			ork Order up				
Work Orde	or.					DISPOSITION			,	AGAI	NST DE	PARTMENT,	PROCESS		Reg T	
Work Orac					—	Rework	٦		Skid-tube	Crosst	uhe	Water Jet			Engineering	
Part N	lo.					Scrap	1		Machining	Small		Pro	d. Eng. Coor.		Quality	
	•					Use-as-is	1 1		noforming	Finisi	-		e/Packaging		Other	
NCR N	lo.					Suspected Unapproved	1		Large Fab	Compo	· •		Supplier			
						<i>:</i>			*							
Root					Desc	ription of work order update		nitial	2	Action		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	С	escription		Date	Verification	<u> </u>	QC Inspector	
Design												,				
Doc/Data										a a						
Equip/Tooling							1									
Handling/Pre	_															
Material	_															
Operator	_															
Offset/Setup	_					•				•						
Process	_		]													
Supplier							1									
Training -	$\dashv$															
Transport	-		E													
Unapproved			<u> </u>				50	III T CA	TECORY							
Landi		`				Company	FA	ULI CA	TEGORY							
Landii	$\overline{}$	Bending				<b>General</b> Bend		احمانه رو	Program			Outside Dim	oncions		Pressure/Forced	
•	-	Centre No	at Cancar	atric	$\vdash$	BOM/Route	$\vdash$	Grain	Togram			Over/Under		-	Set-up	
		Cracks	or concer	itric	-	Broken/Damage/Defect	$\vdash$	Hardwa	aro.	تغوره	_	Part Incorred		-	Temperature/Cure	
		Crimp/Kir	nk/Rinnle	: -/\/ave	-	Burrs		ł		te/Unqualified	·	Part Lost/Mi		-	Weld	
		•	ik/itippie	y wave	$\vdash$	Contamination		4	tions Incomple			Part Moved		Н	Wrong Stock Pulled	
					Countersink	$\vdash$	-	gned/off cen			Positioned V	Vrong				
		Heat Trea	ıt			Cut Too Short	<b> </b>	Mislabi				Power Loss/			Other	
					Drawing	<b> </b>	Misrea				1. 22. 2000/	· · O <del>-</del>				
	Marks/Chatter Drill Holes					<b>-</b>	-	Off-set								
								4	Calibration							
	Turning Sequence Wave/Twist in Tube					Fit/Function -		4	Sequence						· · · · · · · · · · · · · · · · · · ·	

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	114233
Description: Float Skidtube (412)	Part Number:	D3391-3
Inspection Dwg: D3391 Rev: I		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	·	La	the Section	n	T.	
14.000	+/-0.010	14.00				
3.500	+/-0.010	3.525	M		g de la companya de la companya de la companya de la companya de la companya de la companya de la companya de	
Ø3.200	+/-0.010	3,202	/		7	
Ø3.750	+/-0.010	3.750	-		4	
30° x 0.060 chamfer	+/-0.010	300×.063		,		
88.93	+/-0.030	88.73				

Measured by: 9777.1 Date: 14/08/19

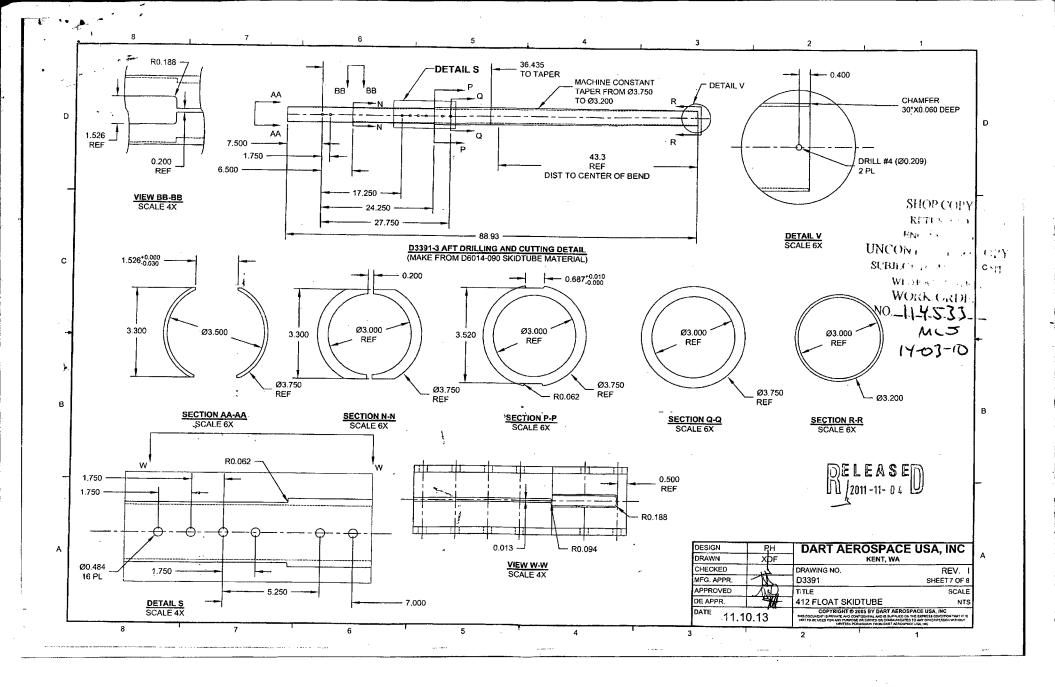
Audited by: Date: 14-10-21

		H	AAS Section	``` }* <b>=</b>	*** X X X X
1.526	+0.000/-0.030	1,514		CNGOZ	Veen:
7.500	+/-0.010	7	507	Itaas I	<b>"</b>
27.750	+/-0.010	276746			₹'
31.750	+/-0.010	31.76			
35.250	+/-0.010	35.252			
3.300	+/-0.010	3.290		5105	Mic
0.200	+/-0.010	.200			
3.520	+/-0.010	3.527		5105	
0.687	+0.010/-0.000	.689		CNCOZ	
R0.062	+/-0.010	.062			
Ø0.484	+0.005/-0.00 <b>b</b> A	s .484		Gace Pin	

Measured by: 9.89/4-10-10 Date: Date: 14/15/1/14-10-12

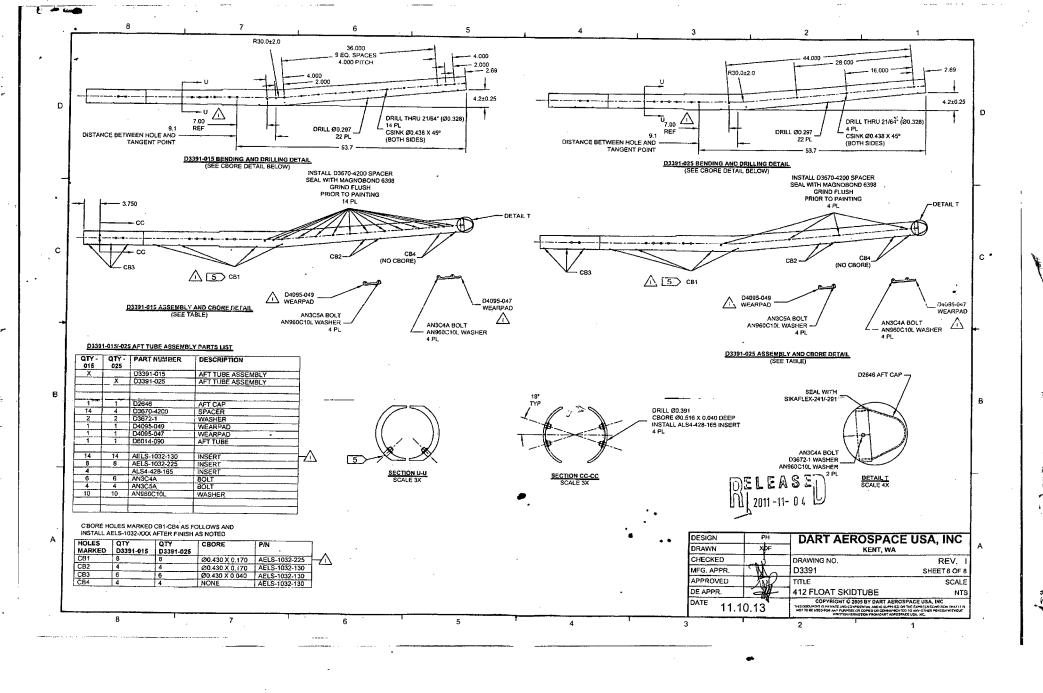
Rev	Date	Change	Revised by	Approved
Α	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
В	06.06.19	Dwg revision update	KJ/JLM	
С	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
Ε	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per,Rev H and NCR09-028	· KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
. Н	11.06.21	Dimension 44.995 removed	KJ	
Ī	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ M	<b></b>
L	12.11:28	88.93 dimension added	KJ 😽	A\
			• (/	

DQA:			Date:	_									DART			
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCI	E/U	*	Vork Ord	ler up	odate only		AEROSPACE
-		, A1				DISPOSITION				,	AGAINST D	EPARTM	1ENT	/PROCESS		
Work Orde	r: -				[		,			<b>—</b> ,		7		· ·	$\overline{}$	·
Part N	lo.			-		Rework Scrap			Skid-tube Machining		Crosstube Small Fab			Water Jet d. Eng. Coor.		Engineering Quality
NCR N	NCR No.			<del></del>	Use-as-is Suspected Unapproved		Thermoforming Finishing Rec/Store/Packagin Large Fab Composite Supplie					re/Packaging Supplier	-	Other		
Root					Desc	ription of work order update		nitial	nitial Action			Sign	&		$\Box$	
Cause	i	Date	Step	Qty		or non-conformance	Ch	ief Eng		Desc	ription	Da	te	Verification	n	QC Inspector
Design																
Doc/Data			i						ا <b>م</b> سہ						İ	
Equip/Tooling							ļ	•								
Handling/Pre											,					
Material														:		
Operator											J					
Offset/Setup		:										Ì				
Process			1													
Supplier																
Training						<i>*</i>										
Transport			1		'	•										
Unapproved				l												
		•					FA	ULT CA	TEGORY	,						
Landi	ng (	Gear				General		_				<u>.</u>				
		Bending				Bend		Folio/F	rogram			Outsid	e Dim	ensions		Pressure/Forced
		Centre No	ot Conce	ntric		BOM/Route		Grain				Over/l	Jnder	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are			Part In	corre	ci		Temperature/Cure
1		Crimp/Kir	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomp	lete/U	nqualified	Part Lo	st/M	issing	$\Box$	Weld `
		Cuffs				Contamination		Instruc	tions Incom	plete/	Unclear	Part M	loved		П	Wrong Stock Pulled
	<b>├</b>				Countersink		Misali	gned/off co	enter	. [	Positio	ned V	Vrong	_	r milita kapa	
		Heat Trea	at	Cut Too Short				Mislab	-			Power	Loss/	Surge	$\Box$	Other
• •		ł		trip in Tube Drawing				Misrea						!		
1.	_	Marks/Ch				Drill Holes		Off-set								
and the same of th						Finish		4	Calibration			· · · ·	_	,		
	Turning Sequence Wave/Twist in Tube					Fit/Function		- 4	Seauence		+	-		-		



,

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON	-((	JNFO	RIMANCE / UI		ork Order up	date only	AEROSPACE		
14/I- OI-						DISPOSITION				AGAINST DE	PARTMENT	PROCESS			
Work Orde	er: _					, ,_	,		or the same	Current in a	1	Water Jet	] Engineering		
Part N	lo.					Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab	Pro	d. Eng. Coor.	Engineering Quality		
raitiv	٠٠				—	Use-as-is			noforming	Finishing	4	e/Packaging	Other		
NCR N	۰. ما ا					Suspected Unapproved	]		Large Fab	Composite	]	Supplier			
Root					Descr	ription of work order update	1	nitial	1 - 1						
Cause		Date	Step	Qty	1	or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector		
Design	_												·		
Doc/Data															
Equip/Tooling	_														
Handling/Pre															
Material															
Operator	$\dashv$					•									
Offset/Setup	$\dashv$														
Process	$\dashv$														
Supplier	$\dashv$														
Training -	$\dashv$														
Transport	$\dashv$								•			ļ.			
Unapproved	L		L	<u> </u>		,		III T CAT	l regory			<u> </u>	<u> </u>		
Landir						General .	FA	OLI CA	EGORT			· · · · · · · · · · · · · · · · · · ·			
Landii		ear Bending				Bend		lealia/B	rogram		Outside Dim	ensions	Pressure/Forced		
	_	Centre No	nt Cancar	atric		BOM/Route	-	Grain	Togram	_	Over/Under	,	Set-up		
	_	Cracks	ot Concer	ILIIC		Broken/Damage/Defect	$\vdash$	Hardwa	ro	·	Part Incorre		Temperature/Cure		
		Crimp/Kin	k/Rinnle	/\\/ave	-	Burrs		1	ion Incomplete/Ur	ogualified —	Part Lost/Mi	<u> </u>	Weld		
	_	Cuffs	ik) hippie	, wave	-	Contamination	-	1 '	ions Incomplete/U	<u> </u>	Part Moved		Wrong Stock Pulled		
	_	Crushing				Countersink	$\vdash$	4	ned/off center	—	Positioned V	L Vrong	J 20 2.220 424		
ł	_	Heat Trea	t			Cut Too Short		Mislabe		<del> </del>	Power Loss/		Other		
ŀ	<b>├</b>					Drawing		Misread		<u> </u>	<b>_</b>		<u> </u>		
ľ						Drill Holes		Off-set					· · ·		
						Finish	Out of Calibration								
		Wave/Tw	-			Fit/Function		4	Sequence		·		7.00		



OA Closed: Date:  Work Order:  Part No.  Part No.  NCR No.  DISPOSITION  Rework Scrap Use-as-is Suspected Unapproved  Root Cause Date Step Qty Description of work order update Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Suspelier  Date:  Work Order update only AGAINST DEPARTMENT/PROCESS  Skid-tube Machining Small Fab Prod. Eng. Coor. Qt. Thermoforming Finishing Rec/Store/Packaging Composite  Composite Sign & Composite  Description Date Verification QC In Description Offset/Setup Process Supplier	ADT				,	•	_			Date:		DQA:
Work Order:    Part No.	EROSPACE	ate only	ork Order up		RMANCE / UF	CONFO	WORK ORDER NON			Date:	, , , ,	QA Closed:
Rework Scrap Use-as-is Suspected Unapproved Use-as-is Suspected Unapproved Date Step Oty Or non-conformance Chief Eng Description Date Verification Offset/Setup Process Supplier		- J. T.			DISPOSITION							
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC In  Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process  Supplier	eering Quality Other	Eng. Coor. Packaging	1	Small Fab Finishing	Machining moforming		Scrap Use-as-is	· .		,		Part No
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier			Sign &	tion *	Acti	Initial	cription of work order update	Descr				Root
Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier	Inspector	Verification QC	Date	ription	Descri	Chief Eng	or non-conformance	,   .	Qty	Step	Date	Cause
Transport Unapproved S												Doc/Data  Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport
FAULT CATEGORY	<del></del>		41		TEGORY	FAULT CA				•		
Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld	e/Forced ature/Cure Stock Pulled	Ilerance Set-up Tempe Weld Wrong ong rge Other	Over/Under t Part Incorrect Part Lost/Mis Part Moved Positioned W Power Loss/S	/Unclear	are tion Incomplete/Un tions Incomplete/U gned/off center eled d Calibration	Grain Hardwan Inspect Instruc Misali Mislab Misrea Off-set Out of	Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	re	:/Wave	t n Strip in atter equence	Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Turning So	